

Work Order ID 58973

Thursday, May 20, 2010 12:37:26 PM



Page 1

Item ID: D3805-7

Accept



Setup Start



Revision ID:

Item Name: Plate

Stop



Start Date: 5/20/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 5/31/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: HLDate: 10-5-20

Tooling:

Date:

Run Start



QC:



Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3805	Rev A								
100		0.00							
									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3805								
304 .050	Dwg Rev: <u>A</u>								
	Prog Rev: <u>A</u>								
	2-Deburr if necessary								
110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

10-6-9210-6-9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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Start Date: 5/20/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 5/31/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

S 10/6/09



QC

Memo

0.00

Quality Control

(2)

130

0.00



Brake NC

Memo

0.00

Brake NC

Form as per Dwg D3805 using Jigs DT8261 and DT8326

SB 10/02/16

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S 10/6/16

(2)

W/O:		WORK ORDER CHANGES					
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Page 3

Item ID: D3805-7

Accept



Setup Start



Revision ID:

Item Name: Plate

Stop



Start Date: 5/20/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 5/31/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: W/S

0.00



Packaging

Memo

0.00

Packaging

EL 10-6-22 (X2)

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/23 HJBS 10-6-22
(2)

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NOTE: Date & initial all entries

Picklist Print

Thursday, May 20, 2010 12:37:31 PM

Page 1

Work Order ID: 58973

Parent Item: D3805-7

Parent Item Name: Plate

Comments:

Start Date: 5/20/2010

Required Date: 5/31/2010

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
M304S18GA		Purchased	No			100	sf	140.0179	2.091			



304/316 .050 Sheet



10-6-9

Location

Loc Qty

Loc Code

MAT20

140.0179

108156

1.7

111743

10.1

112885

32.2179

113062

96

112885

2

W/O:		WORK ORDER CHANGES					
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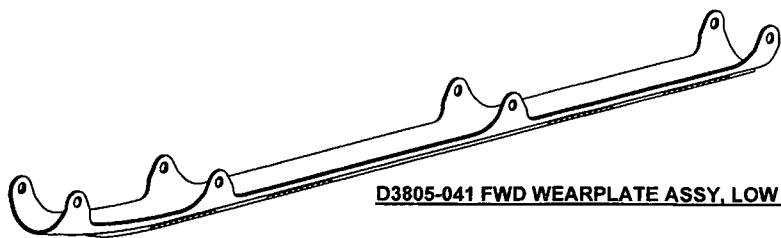
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

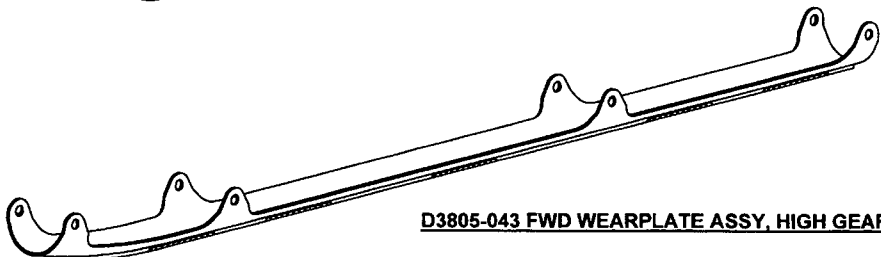
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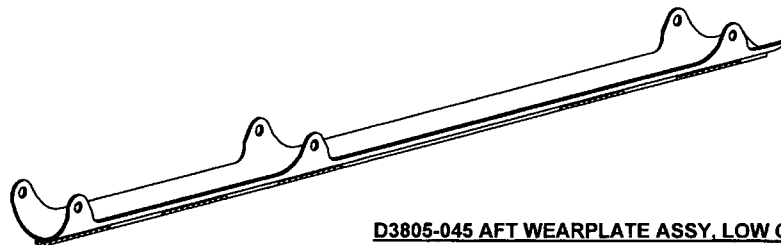
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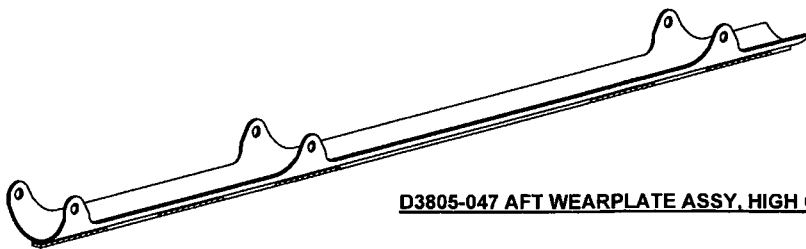
D3805-041 FWD WEARPLATE ASSY, LOW GEAR



D3805-043 FWD WEARPLATE ASSY, HIGH GEAR



D3805-045 AFT WEARPLATE ASSY, LOW GEAR



D3805-047 AFT WEARPLATE ASSY, HIGH GEAR

8 7 6 5 4 3 2 1

ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
1	X				D3805-041	FWD WEARPLATE ASSY, LOW GEAR
2		X			D3805-043	FWD WEARPLATE ASSY, HIGH GEAR
3			X		D3805-045	AFT WEARPLATE ASSY, LOW GEAR
4				X	D3805-047	AFT WEARPLATE ASSY, HIGH GEAR
11	1				D3805-1	PLATE
12		1			D3805-3	PLATE
13			1		D3805-5	PLATE
14				1	D3805-7	PLATE
15	1				D3806-1	BAR
16		1			D3806-3	BAR
17			1		D3806-5	BAR
18				1	D3806-7	BAR
19	1				D3807-1	GASKET
20		1			D3807-3	GASKET
21			1		D3807-5	GASKET
22				1	D3807-7	GASKET
31	A/R	A/R	A/R	A/R	2059B	HARDCOAT
32	A/R	A/R	A/R	A/R	1300 (OR 1300L)	3M SCOTCH-GRIP ADHESIVE

SHOP COPY
RETURN TO
ENGINEERING.
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 58923
BS10-5-20

RELEASED
09.03.03
P4 ECN 09.538

A	NEW ISSUE	MB	08.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.11.21		

DART AEROSPACE USA, INC.
PORT HADLOCK, WA

DRAWING NO. **D3805** REV. A
SHEET 1 OF 8

TITLE **WEARPLATE ASSY** SCALE NTS

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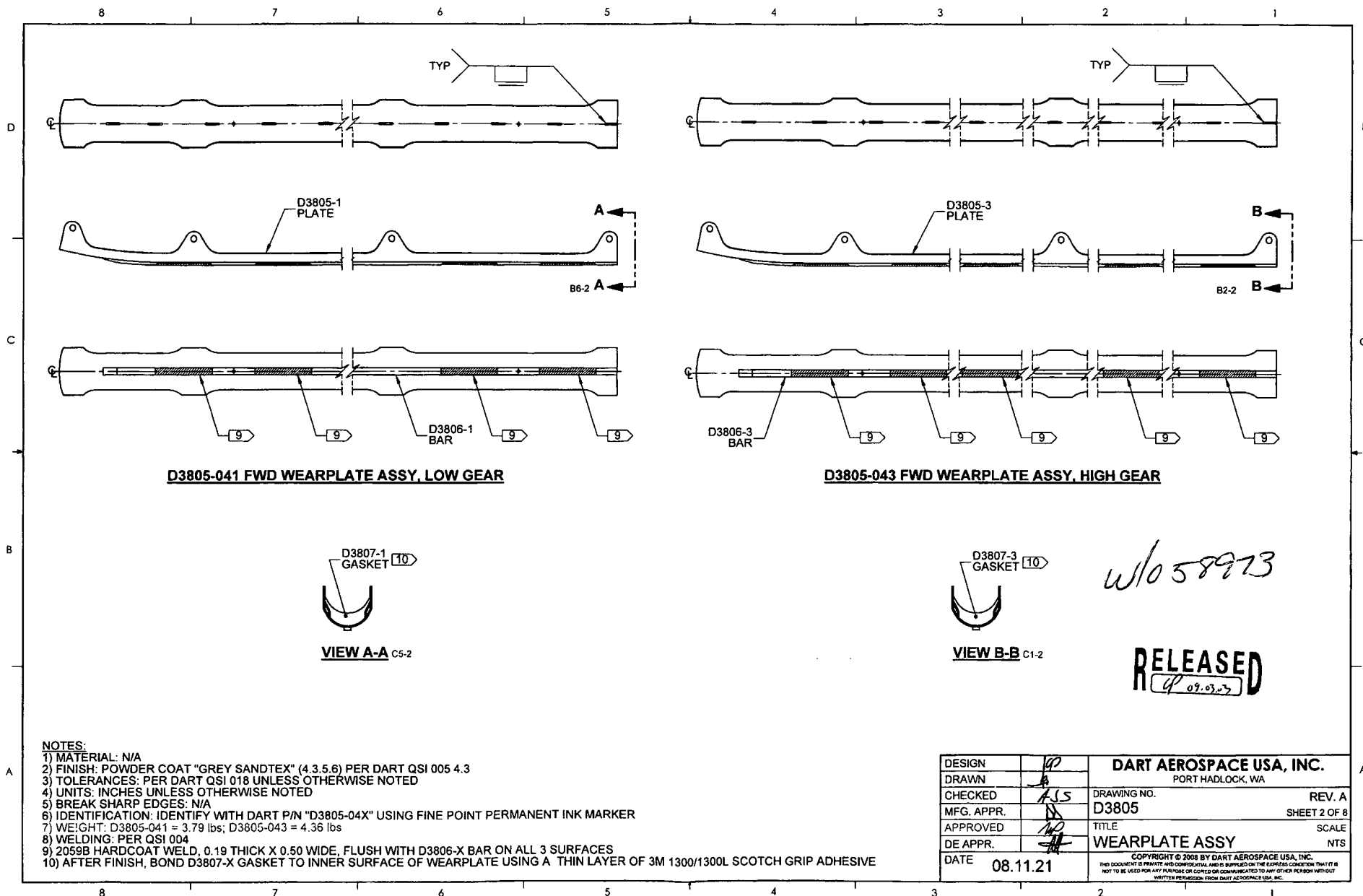
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



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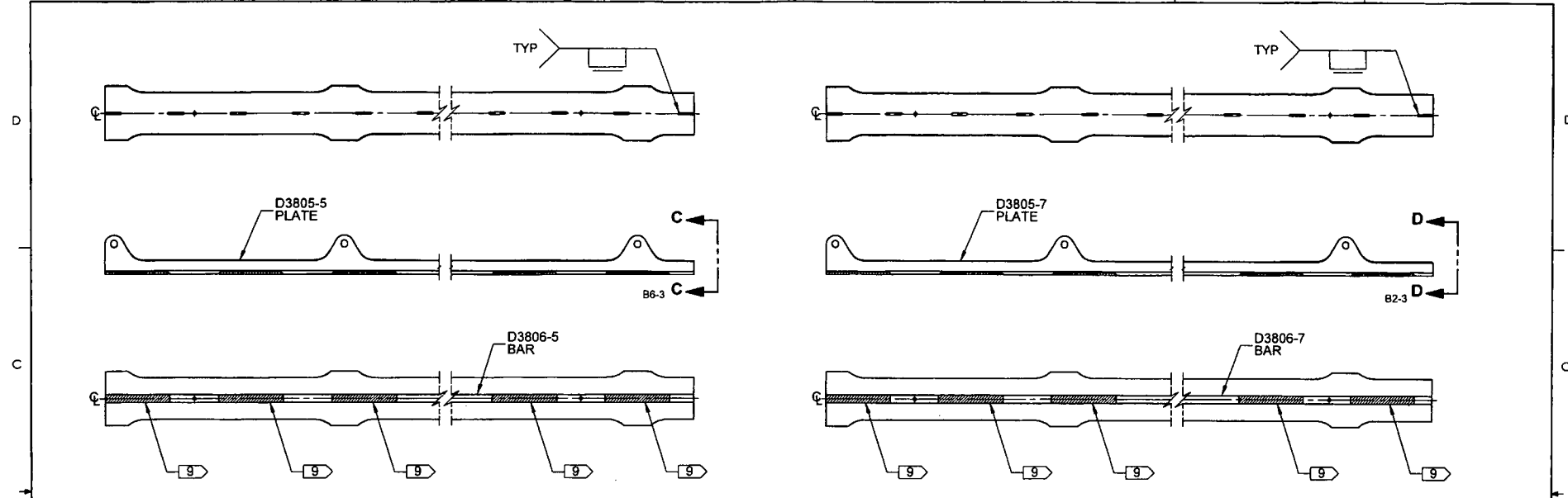
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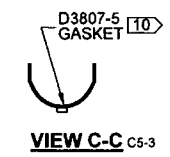
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D3805-045 AFT WEARPLATE ASSY.

D3805-047 AFT WEARPLATE ASSY.



RELEASED
09.03.07

W/O 58973

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3805-04X" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: D3805-045 = 3.93 lbs; D3805-047 = 4.21 lbs
 - 8) WELDING: PER QSI 004
 - 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D3806-X BAR ON ALL 3 SURFACES
 - 10) AFTER FINISH, BOND D3807-X GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

DESIGN	10	DART AEROSPACE USA, INC.	
DRAWN	8	PORT HADLOCK, WA	
CHECKED	755	DRAWING NO.	REV. A
MFG. APPR.	11	D3805	SHEET 3 OF 8
APPROVED	11	TITLE	SCALE
DE APPR.	11	WEARPLATE ASSY	NTS
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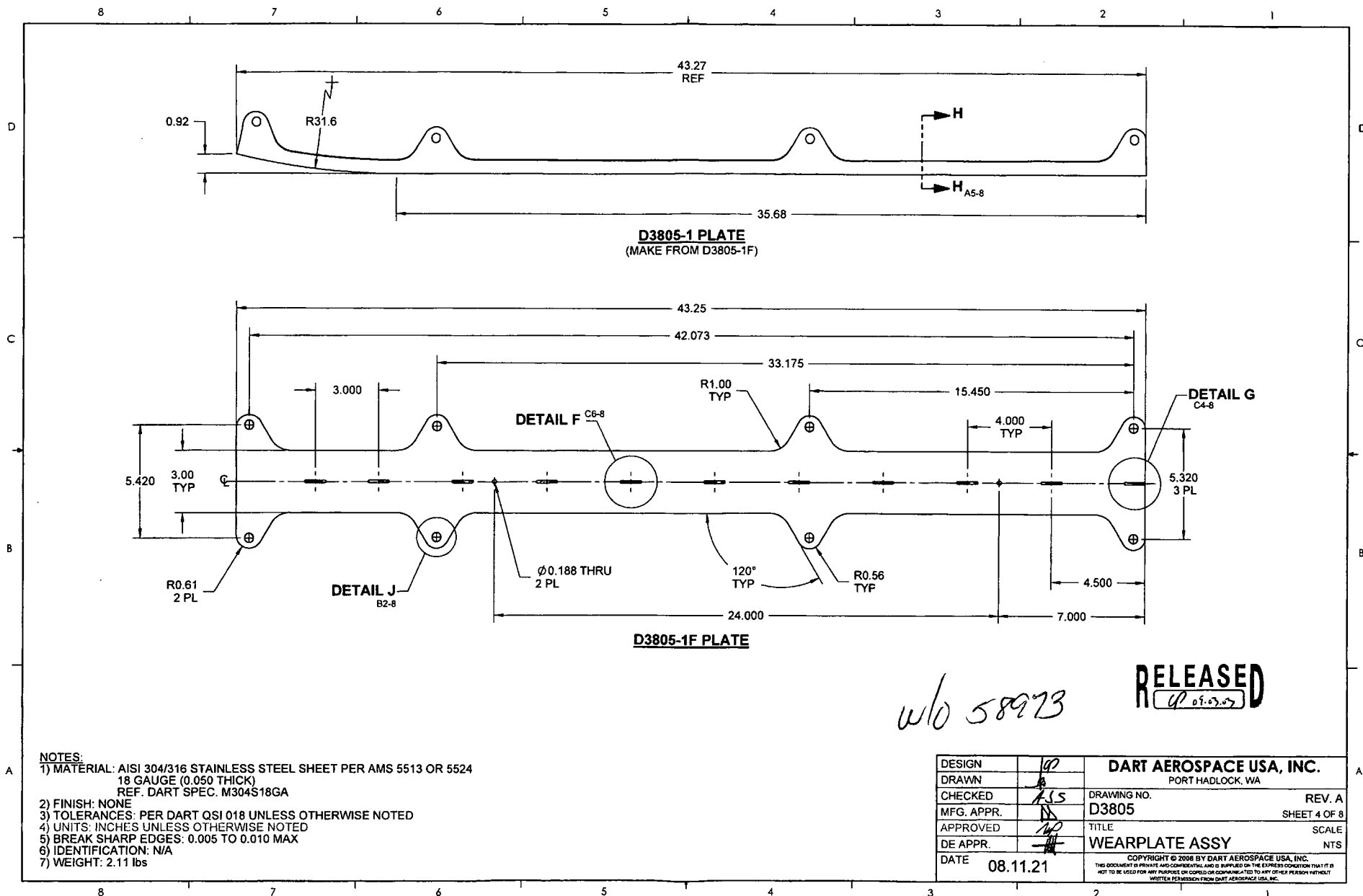
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RELEASED
09.03.07

w/o 58973

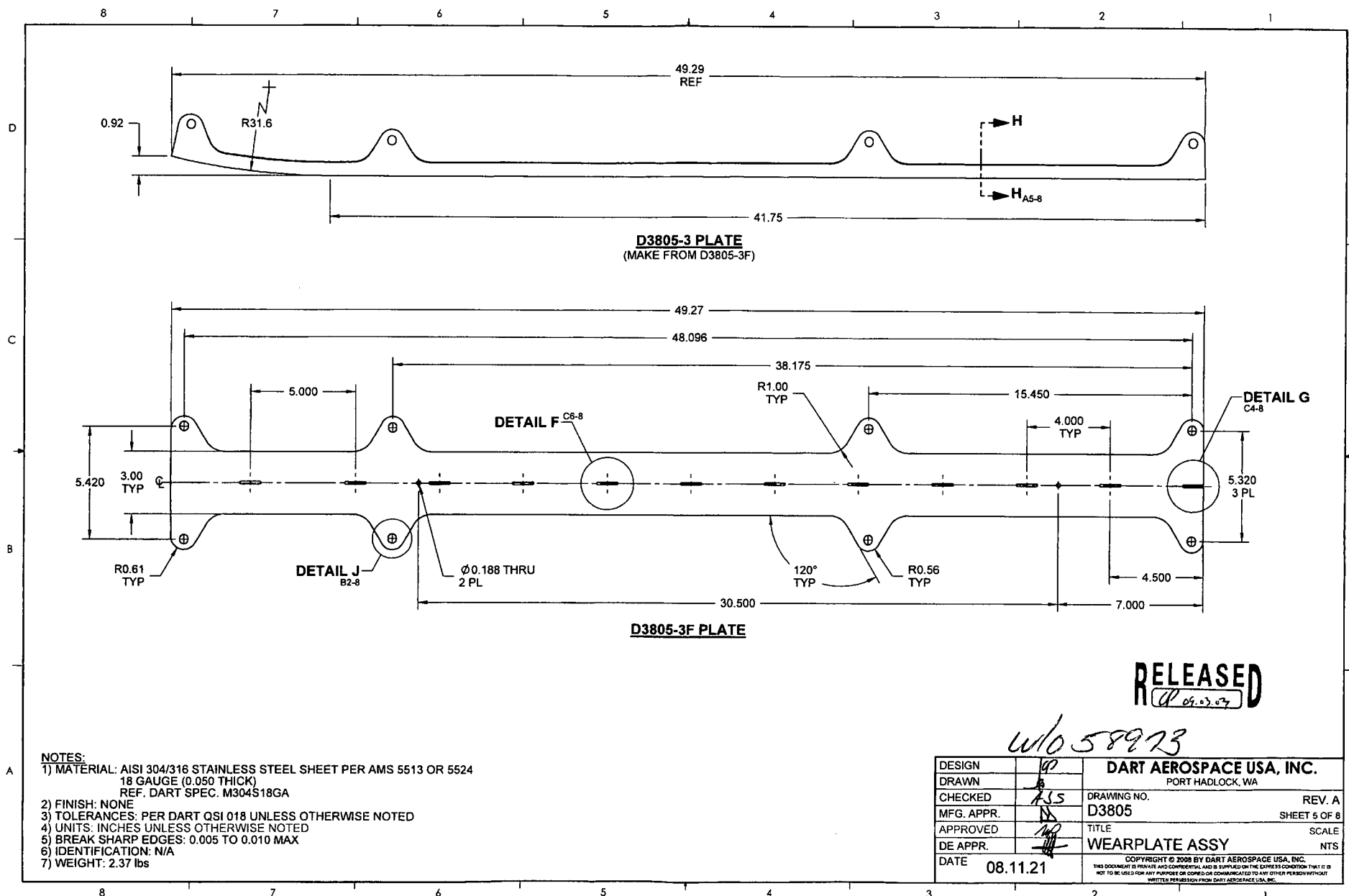
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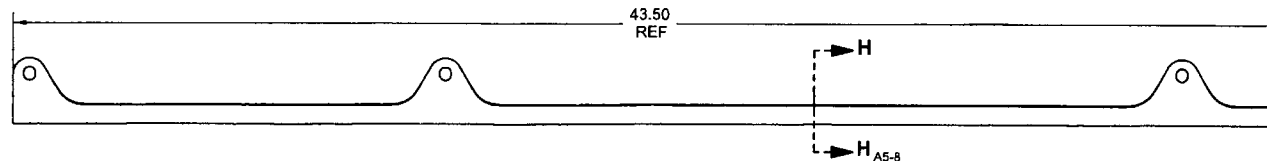
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8 7 6 5 4 3 2 1

D

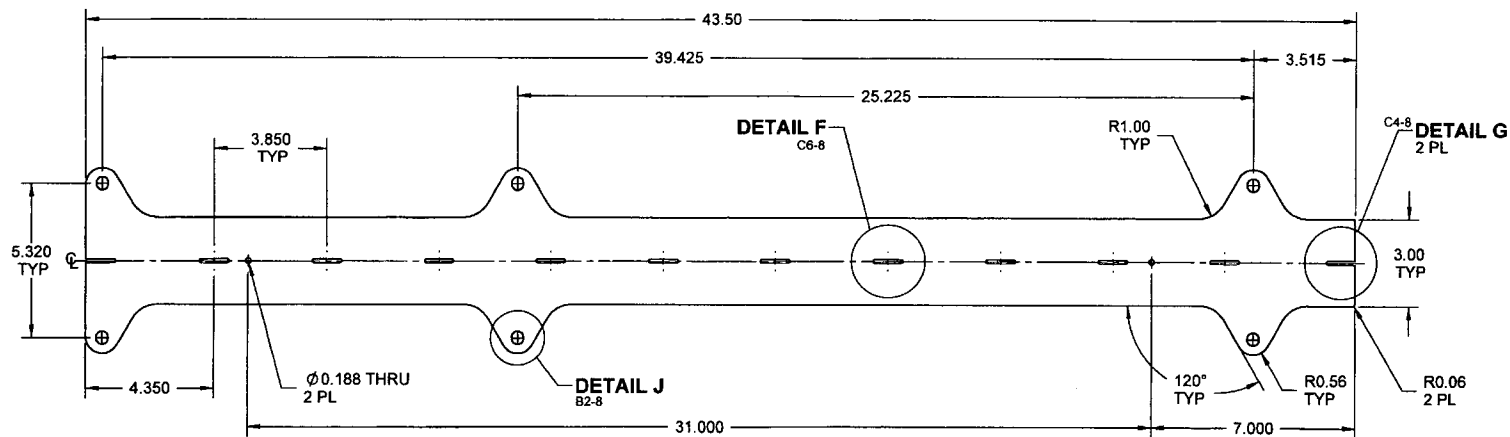
D



D3805-5 PLATE
(MAKE FROM D3805-5F)

C

C



D3805-5F PLATE

RELEASED
47 09 03 03

W/O 58973

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.06 lbs

DESIGN	JP	DART AEROSPACE USA, INC.	
DRAWN	JP	PORT HADLOCK, WA	
CHECKED	JS	DRAWING NO.	REV. A
MFG. APPR.	JS	D3805	SHEET 6 OF 8
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	WEARPLATE ASSY	NTS
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8 7 6 5 4 3 2 1

A

A

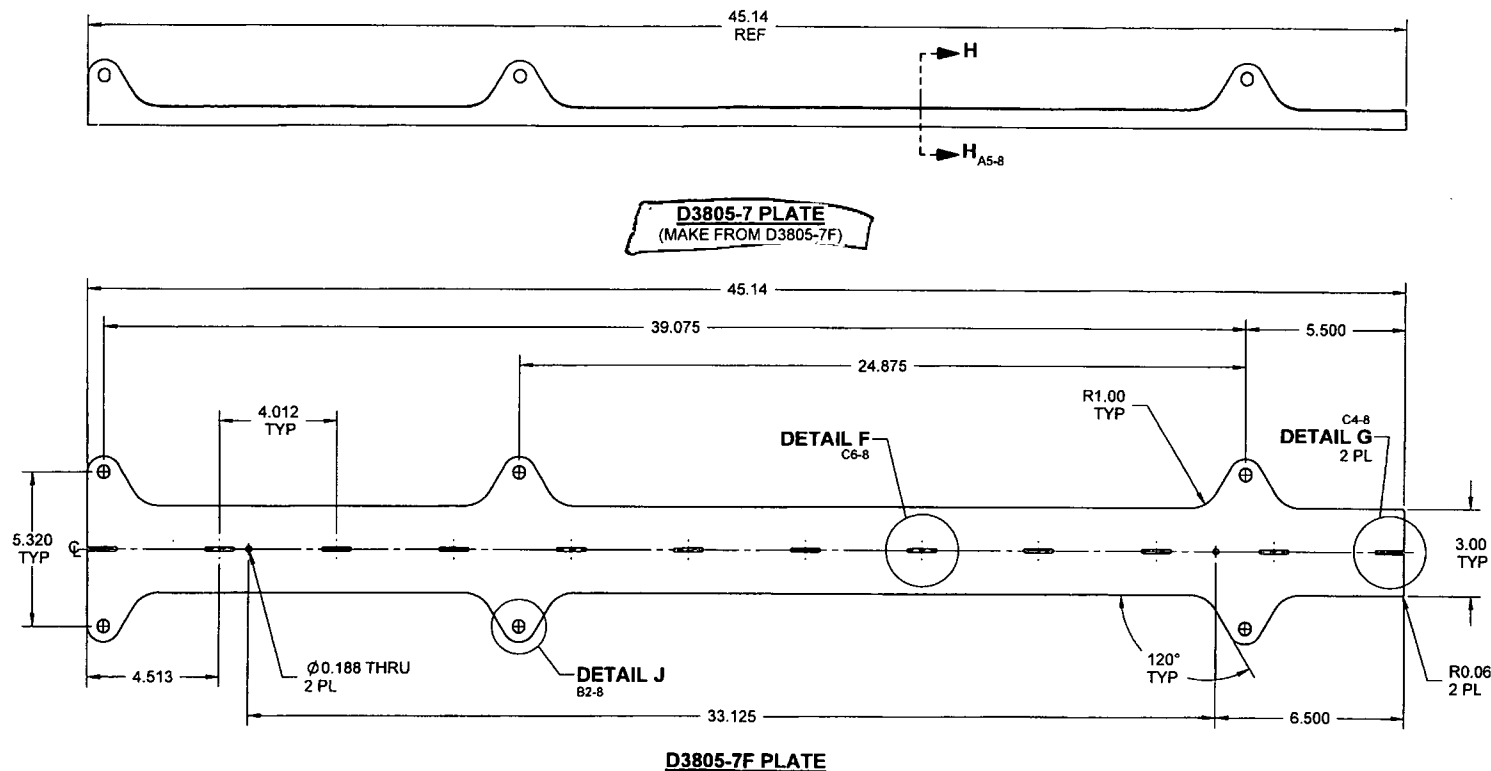
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RELEASED
09.03.03

NOTES:

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- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.13 lbs

DESIGN	W/058923	DART AEROSPACE USA, INC.	
DRAWN	ALS	PORT HADLOCK, WA	
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MFG. APPR.	ALS	D3805	SHEET 7 OF 8
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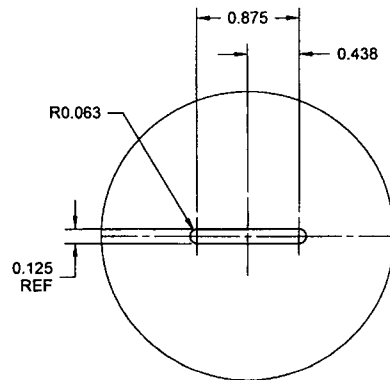
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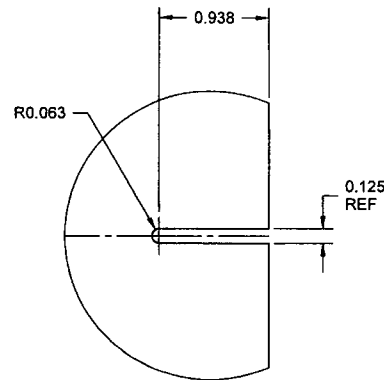
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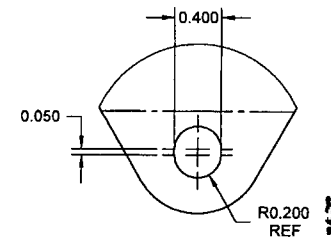
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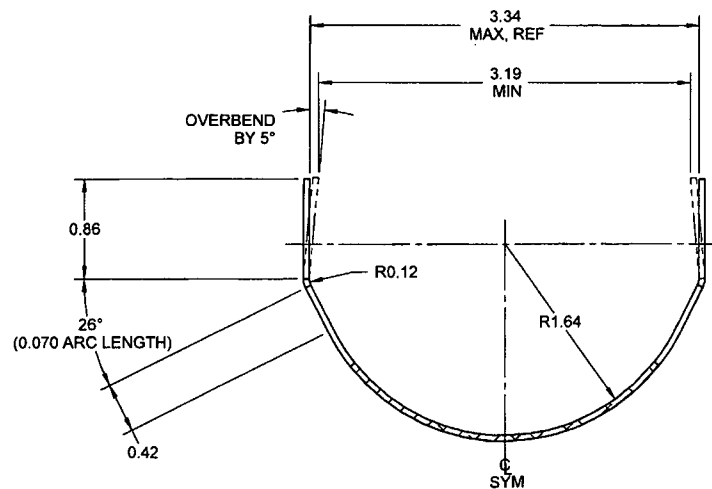
DETAIL F
SLOT DETAIL TYP
SCALE 4X
C5-4
C5-5
C4-6
C4-7



DETAIL G
SLOT DETAIL TYP
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C1-4
C1-5
C1-6
C2-7



DETAIL J
SCALE 4X
B6-4
B7-5
B6-6
B5-7



SECTION H-H
SCALE 4X
D3-4
D3-5
D3-6
D3-7

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4909.93.03

u6 38973

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CHECKED	15	DRAWING NO.	REV. A
MFG. APPR.	15	D3805	SHEET 8 OF 8
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